

Date: Friday, 12/9/2005 12:06:51 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARPAD
<b>Job Number</b> : 25198	
<b>Estimate Number</b> : 11359	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D334023
<b>This Issue</b> : 12/9/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3340 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 12/9/2005 <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> :	<b>Material</b> : N/A
<b>Written By</b> : <u>SEE COMMENT BELOW</u>	<b>Due Date</b> : 12/16/2005 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>SEE ABOVE USER &amp; DATE</u>	
<b>Comment</b> : Est: A 05.11.10 Preliminary issue AP/EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 00000267 05/12/12

Email of ship DXF file to vendor

Laser Cut per Dwg D3340 flat pattern D3340-23

Material release note required

2.0	D334023F	Wearplate
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
 Wearshoe

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material release note is attached

06/02/08(10)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK  
 Inspect dimensions

Jan 17

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Deburr if necessary

Form on brake as per Dwg D3340 using Jigs DT

and DT

SB 06/02/2010

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 06/03/08

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/9/2005 12:06:52 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 25198

Part Number: D334023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*06.02.20* (10)

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*DL 06/03/24* (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*06/03/27* (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *364*

*06/03/27* (10)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/03/28* (10)

Job Completion



*06 03.28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

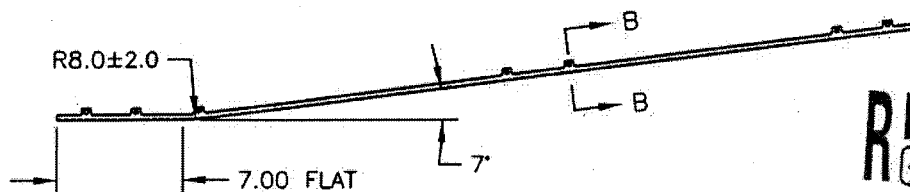
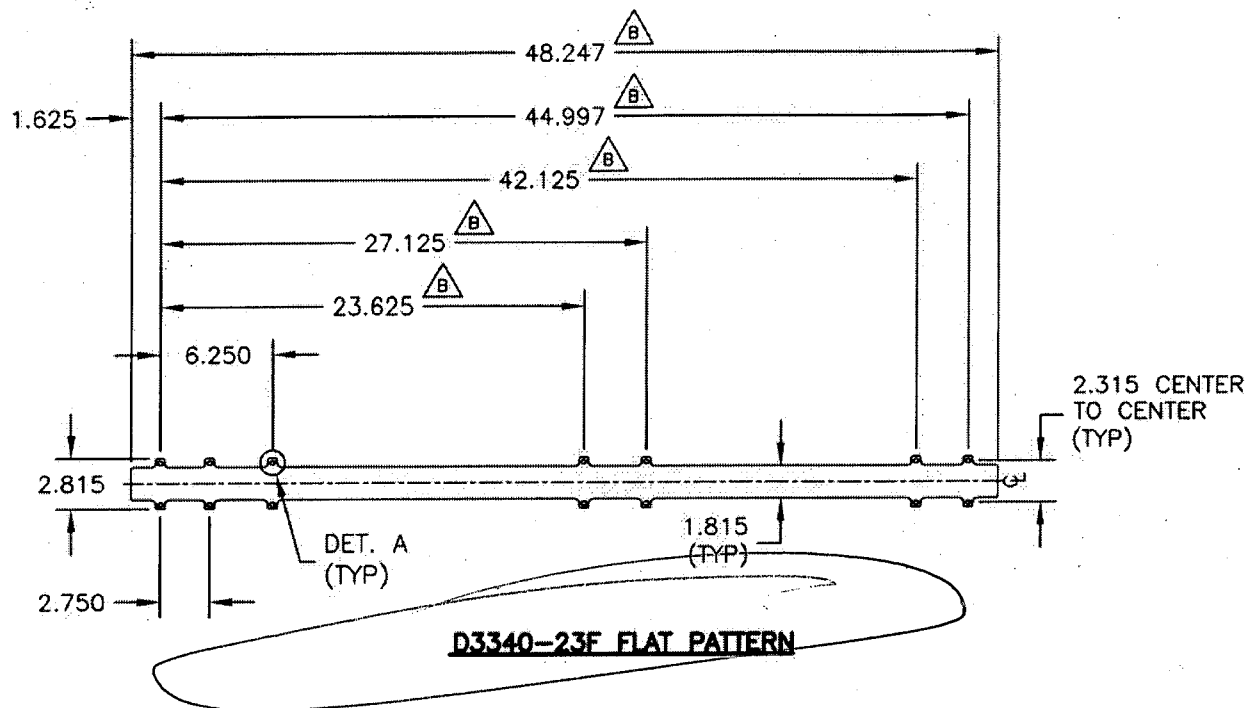
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10

**D3340-23 AFT FLOAT SKIDTUBE PROTECTOR****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR  
ASTM A36/A366/A1008 OR  
CSA G40-21, 38W/44W/50W/60W/70W SERIES  
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)  
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

**RELEASED**  
05.11.28

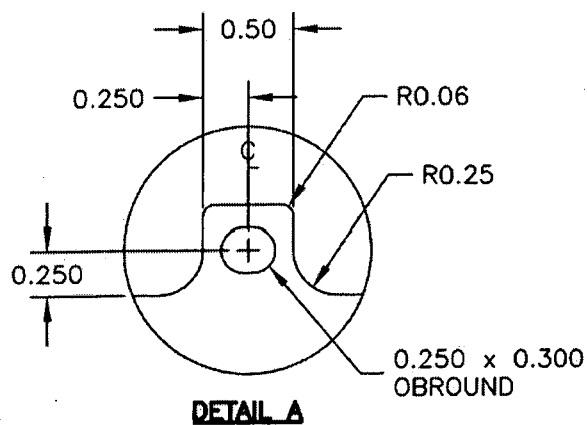
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**WORK ORDER**  
**NO. 25198**

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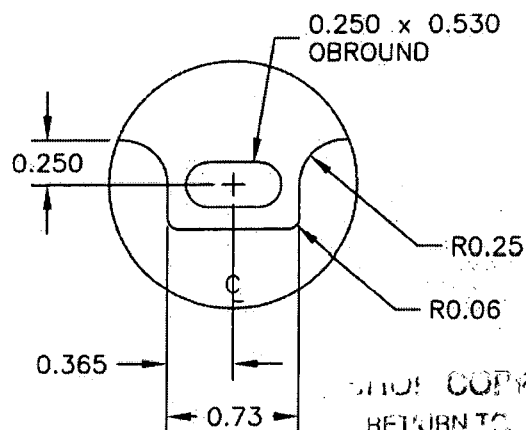
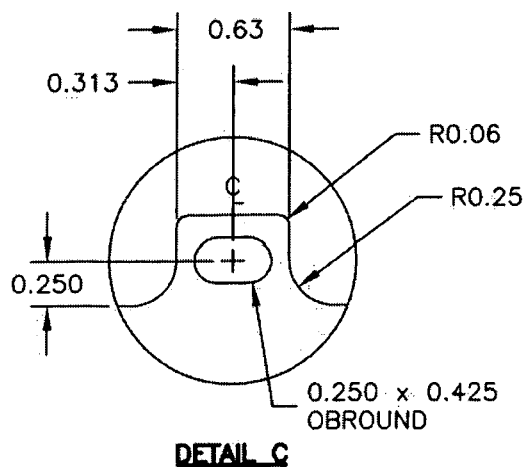
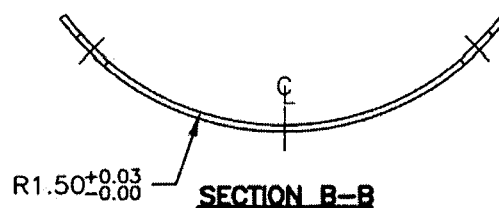
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1



RELEASED  
05-11-28



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New Zealand Steel Limited  
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 Fax: (08) 375 8888

# TEST CERTIFICATE

Ref: 5003/21328

CUSTOMER		Widdison		P41007D1002		SPECIFICATION		ASTMA1008 CS Type A		CERTIFICATE No		TC107796														
CUSTOMER Q/N		90-11N-288				PRODUCT		CRA WIDE COIL		PAGE		1 of 1														
MILL Q/N		453665				DIMENSIONS		6.031" x 48" x Coil		DATE		11 March 2005														
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)										
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH		
		x100				x1000										x10000		x100		180°				HRB	( )	(feet)
R9-455932-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2621		
R9-455933-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2723		
R9-455934-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2546		
R9-455935-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2789		

P/O 267

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.)			PLASTIC STRAIN RATIO (R)		IMPACT TEST		CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Ni/5)S+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
	(A)=200mm (B)=50mm	(C)=80mm (D)=6.85 ± 0.05	(E)=2" (F)=8"	(A)=r0 (B)=r90	(C)=r45 (D)=(r0+r90+2r45)/4	(A)=10mm x 10mm (B)=7.5mm x 10mm	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
 WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

*Satish Misra*  
 QC METALLURGIST

20 GA CRMS